

Date: Tuesday, 11/29/2005 7:14:14 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET WELDMENT (206)
Job Number : 25049	
Estimate Number : 10477	
P.O. Number : N/A	Part Number : D2413
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D2413 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
Type : LARGE FAB ASSY	Due Date : 12/13/2005
Written By : <u>EST C 03.04.14 KSK/RE</u>	Qty: 2 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Created By Auto Work Order	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Heater Tube 4"

Qty	Part Number	Description	Batch
1	D2292	4" Ring	B21844

06/05/16 (2)

Tools:

2.0	D2405	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 End Plate

Qty	Part Number	Description	Batch
1	D2405	End Plate	B24398

06/05/16 (2)

Tools:

3.0	D2407	3" Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 3" Tubing

Qty	Part Number	Description	Batch
1	D2407	3" Tubing	B26915 / B24398

06/05/16 (2)

Tools:

4.0	D2408	Locator Cross
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Locator Cross

Qty	Part Number	Description	Batch
1	D2408	Locator Cross	B24398

06/05/16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:14:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 25049

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

Tools:

5.0

D2409

Jet Pipe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Jet Pipe

Qty Part Number

Description

Batch

1 D2409

Jet Pipe

B25065

06/05/16 (2)

Tools:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2413 Intake Assembly as per Dwg D2413 and QSI 004.

06/05/16 (2)

Tools:

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-05-17 (2)

Tools:

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PPP ~~STAR~~

DL 06/05/23 (2)

Tools:

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

06/05/27 (2)

Tools:

10.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1342

Red Anodize D2413 as per Dwg D2413

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

C 20605126 (2)

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:14:15 PM
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Process Sheet

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Drawing Name: INLET WELDMENT (206)

Job Number: 25049

Part Number: D2413

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PUC/6/5

(PTD)

Tools:

12.0 AN8188D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

1 AN818-8D

Flare Nut

194/13
M-10-100

FF 06-06-23

3

Tools:

13.0 MS208198D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Sleeve

Pick:

Qty Part Number

Description

Batch

1 MS20819-8D

Sleeve

M13230

FF 06-06-23

3

Tools:

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2413. Sleeve & Flare tube as per Dwg D2413

FF 06-06-23

3

Tools:

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16-06-26

3

Tools:

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *S177*

PUC/6/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-06 11		Add QCS Inspect Anodize: cer ts. permanent change QCS by 06-06-06 (Qty 2)		06-07-05			06-06-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2413

Job Number: 

Seq. #: Machine Or Operation: Description :

Tools:

17.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Tools:

DD 06/09/05

Job Completion



CR Dec 30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.



PREPARED		DART AERO ACCESSORIES INC	
B. Williams		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	D2413	REV. A
BW	BW		SHEET 1 OF 2
DATE	TITLE		SCALE
Apr. 6, 1995	206 INLET WELDMENT		

RELEASED
96/09/10 BW

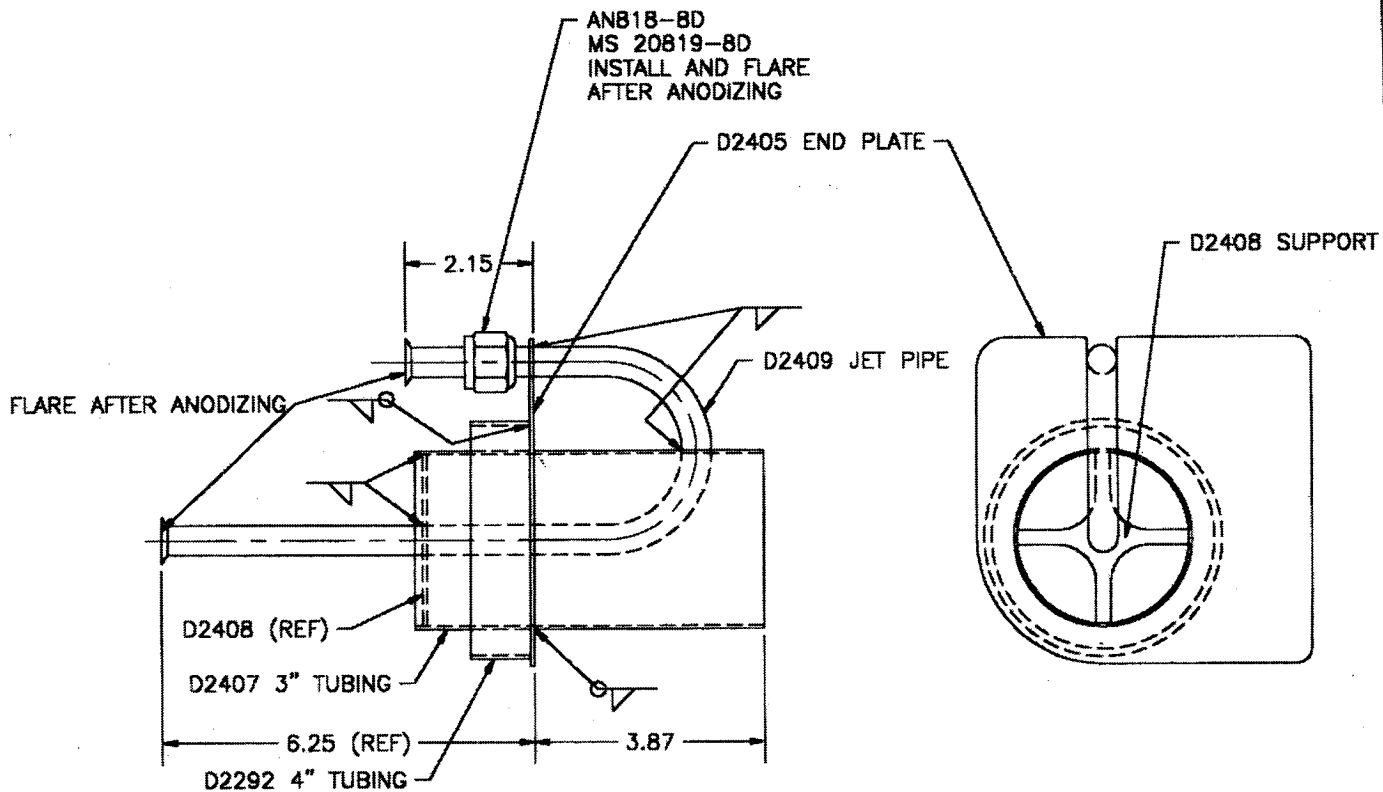
QTY	Part No.	Description
X	D2413	INTAKE WELDMENT ASSEMBLY
1	D2292	4" RING
1	D2405	END PLATE
1	D2407	3" TUBING
1	D2408	LOCATOR CROSS
1	D2409	JET PIPE
1	AN818-8D	FLARE NUT
1	MS20819-8D	SLEEVE

DART



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B	APPROVED B	D2413	REV. A
DATE Apr. 6, 1995	TITLE 206 INLET WELDMENT	SHEET 2 OF 2 SCALE	

RELEASED
7669710 (50)



FINISH: ANODIZE

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

48039

02-Jun-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE: 00001342**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	2	2	D2413 B25019 B25049	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	3	3	D2414 B26906 -	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	2	2	D2413 & D2414 B24398	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: ☐ Directeur de la Qualité / Q.A. Manager ☐